

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019792**Date Inspected:** 09-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Deng Zhi Bing.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK007A-001

Weld No: fit up

Tack Welder: 057244

WPS-B-P-2113

Component; East Tower lift 4, skin A

PCMK: ESD1-FASA4-2C/E-7

Weld No: fit up

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Tack Welder: 202100
WPS-B-T-4114

Component; East Tower lift 4, skin A
PCMK: ESD1-FASA4-2B/E-4
Weld No: 211
Welder: 041271
WPS-B-T-4114

Component; East Tower lift 4, skin A
PCMK: ESD1-FASA4
Weld No: temporary attachments
Tack Welder: 218704, 255865
WPS-B-T-4114

Heat straightening of PCMK, SSD1-FESA6-1-8.15 under approved Heat Straightening procedure, HSR1(B)-11648. The in process temperature was observed as 230°C. The ZPMC CWI was identified as Deng Zhi Bing. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 15mm.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Shao Shi Lag.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path
PCMK: BK007A-053
Weld No: fit up
Tack Welder: 052641
WPS-B-P-2113

Component; Bike Path
PCMK: BK004A2-018
Weld No: 013
Welder: 044541
WPS-B-P-2113

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly
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Quality Assurance Inspector

Reviewed By:	Riley,Ken
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QA Reviewer
